

Work Order ID 72659

Thursday, August 04, 2011 8:15:06 AM



Page 1

Item ID: DSK080

Accept



Setup Start



Revision ID:

Stop



Item Name: D2896-1 TURNING DETAIL

Start Date: 8/4/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK080

Rev A

100

0.00



Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

Memo

Turn blank as per Folio FA167

0.00

RP 11-8-10

5

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

RP 11-8-10

5

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

SL 11-08-11

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date: _____

Run Start



QC: _____

Date: _____

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Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: ASK080

JK 11-08-11



140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/8/15

11-08-12
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 04, 2011 8:15:13 AM

Page 1

Work Order ID: 72659



Parent Item: DSK080



Parent Item Name: D2896-1 TURNING DETAIL



Start Date: 8/4/2011

Required Date: 8/5/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011  17-4 SS Roundbar 6.50"OD		Manufactured	No				Each	5.0000		10			
											28 11-8-10		

Location

MAT047

60945 ✓

Loc Qty

5
5

Loc Code

==

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77659
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485	26.15	3.485	3.485	3.485	3.484	3.484
B	3.990	4.010	26.02	4.002	4.002	4.002	4.002	4.002
C	3.825	3.845		3.837	3.837	3.837	3.837	3.837
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	3.705	3.725		3.714	3.714	3.714	3.714	3.714
G	1.360	1.380		1.370	1.370	1.370	1.370	1.370
H	1.250	1.260		1.258	1.258	1.258	1.258	1.258
I	6.490	6.510		6.500	6.500	6.500	6.500	6.500
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127						
M								
N								
O								
P								

Measured by: DP Date: 11-8-11

Audited by: JK Date: 11-08-11

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SAH</u>

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

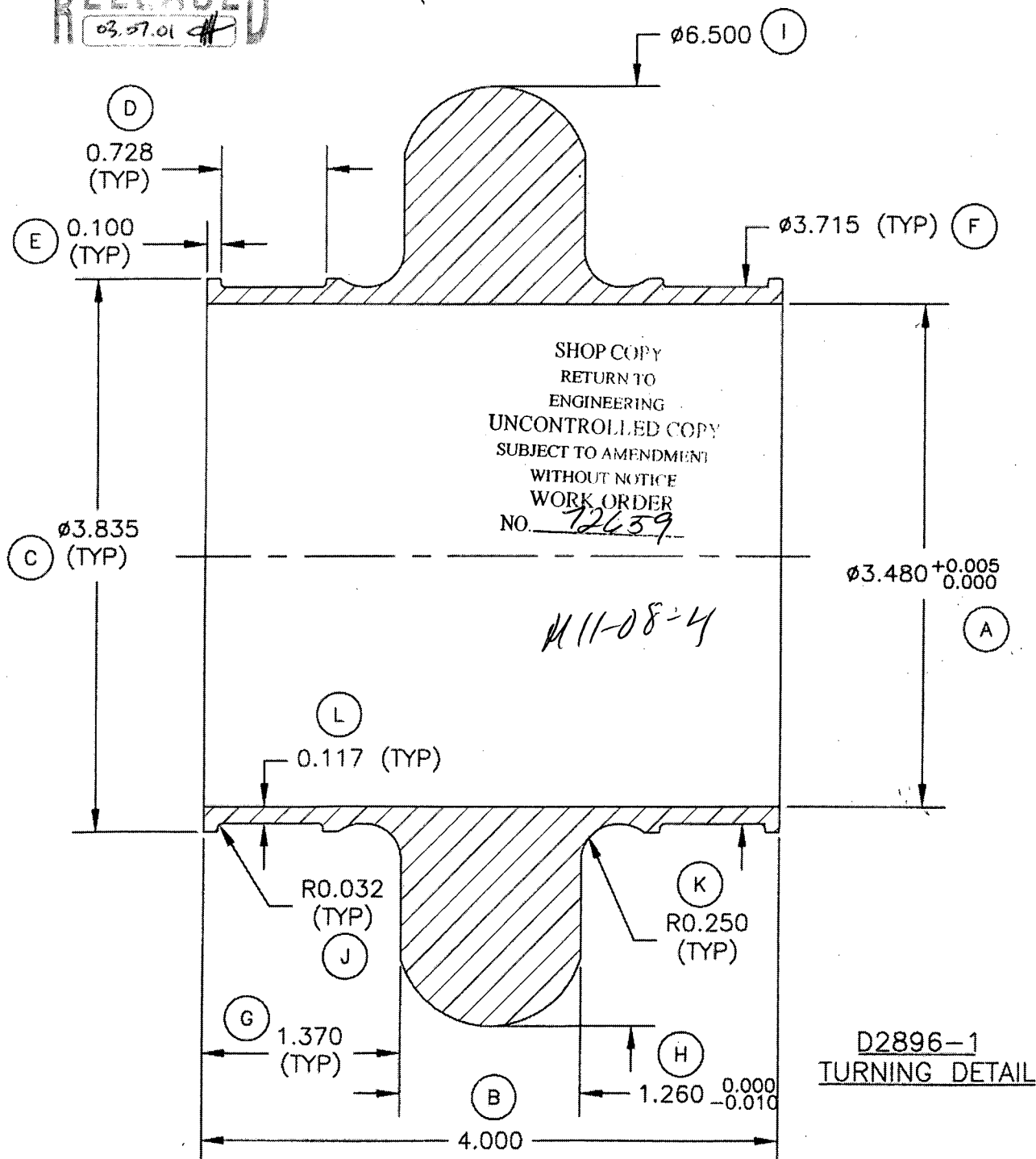
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



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